

Work Order ID 127773

December-17-14 1:53:57 PM

127773

Page 1

Item ID: D3912-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eyebolt Receiver Assy
 Start Date: 12/19/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/19/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3912	B

100 Pick Kit 0.00

100

Packaging Memo 0.00

Packaging

2x

15/03/16 ^{DAS} 36 9-89

110 0.00

110

Small Fab Memo 0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.260" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

2x

15/03/16 ^{DAS} 36 9-89

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00

Quality Control

(2)

^{DAS} 38 9-89
MAR 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST 071A</u>	0.00							
170									
Packaging	Memo	0.00							DAS 6 2-26
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

2 MAR 18 2015

MLJ 15-03-19

mf

15-3-18

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 127773

127773

Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assy

Start Date: 12/19/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 09.11.18 verified by:EC
 10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
 WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
 D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
 FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
 VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R		Purchased	No				Each	103.0000		2			
NAS1149C0663R									**			15/03/16	DAS 36 9-89
Washer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST271				103					
					m126221			103					
D3912-1		Manufactured	No			100	Each	20.0000	1	2			
D3912-1									**			15/03/16	DAS 36 9-89
Eyebolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST065				20					
					122499			10					
					122881			10					
D3912-3		Manufactured	No			100	Each	29.0000	2	4			
D3912-3									**			15/03/16	DAS 36 9-89
Eyebolt Block													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST065				5					
					123374			5					
				ST077A				24					
					122934			24					

B128419
 (42)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Work Order ID: 127773

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assy

127773

D3912-041

Start Date: 12/19/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

D3912-5

Manufactured No

100

Each

93.0000

2

4

D3912-5

Eyebolt Plate

15/03/16
DAS
36
9-89

Location

Loc Qty

Loc Code

ST064A

31

122615

15

123025

16

ST065

18

123441

18

ST077A

44

115773

44

4

D3801-1

Manufactured No

Each

9.0000

2

D3801-1

Hand Retractable Spring Plunger

15/03/16
DAS
36
9-89

Location

Loc Qty

Loc Code

ST060

9

123013

9

100

Each

82.0000

8

16

MS20615-4M20

Purchased No

MS20615-4M20

Rivet

15/03/16
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

82

m130358

82

Each

3.0000

2

MS21209-F615

Purchased No

MS21209-F615

Heli-Coil

15/03/16
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

3

m130325

3

15/03/16
DAS
36
9-89

December-17-14 1:53:57 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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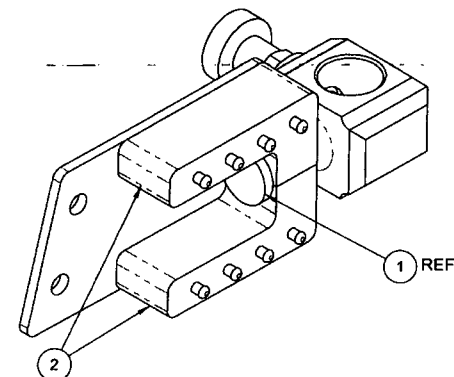
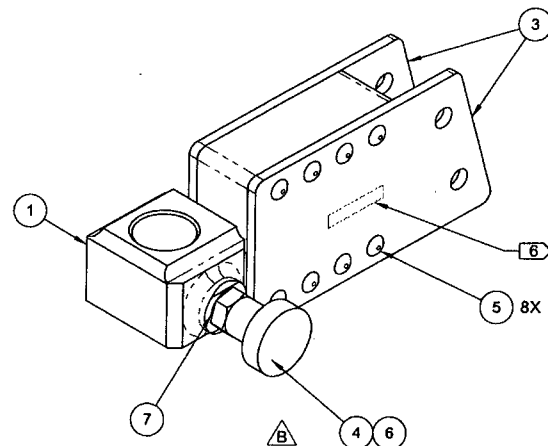
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

127773 MWS
14-12-23

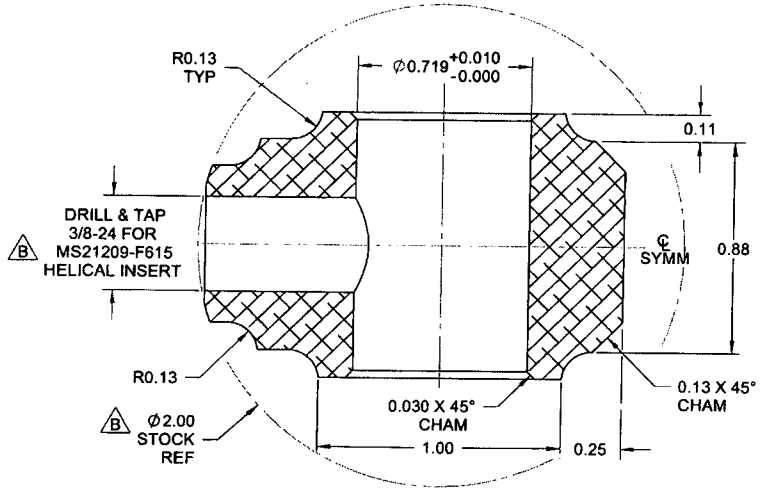
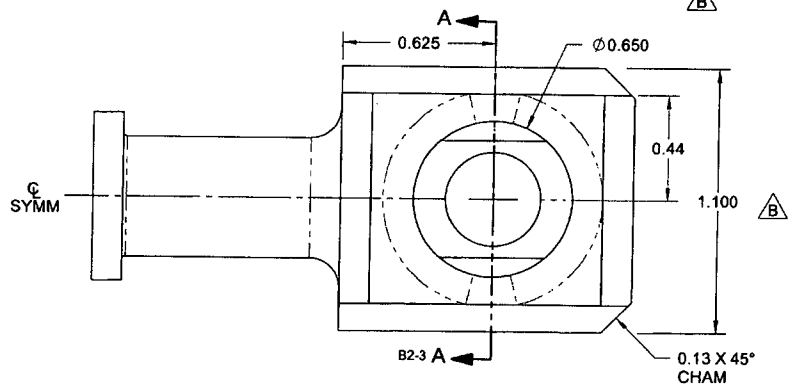
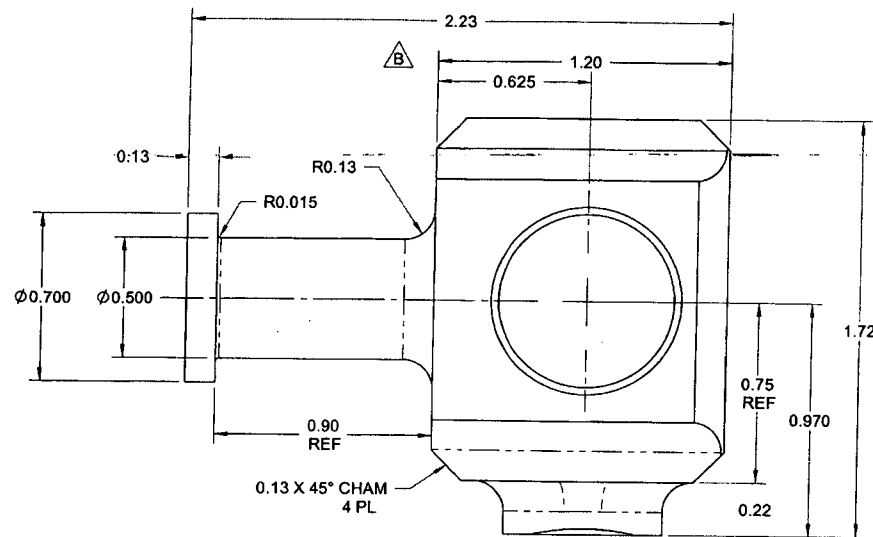
RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0863R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1/15		
DRAWN	1/15		
CHECKED	1/15		
MFG. APPR.	1/15		
APPROVED	1/15		
DE APPR.	1/15		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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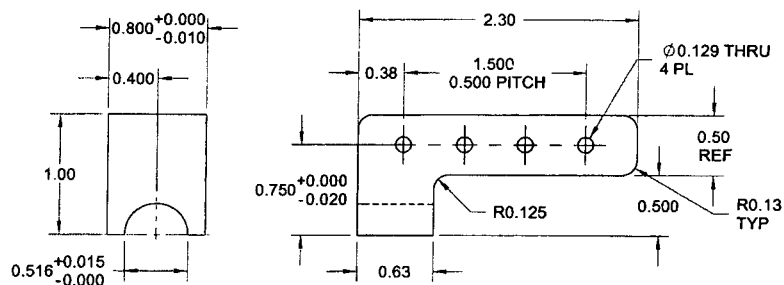
SECTION A-A B6-3

RELEASED
2010-07-16

D3912-1 EYEBOLT

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 REF DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ID AT ASSEMBLY
 - 7) WEIGHT: 0.45 lbs

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	1/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/1	DRAWING NO.	REV. B
MFG. APPR.	1/1	D3912	SHEET 2 OF 3
APPROVED	1/1	TITLE	SCALE
DE APPR.	1/1	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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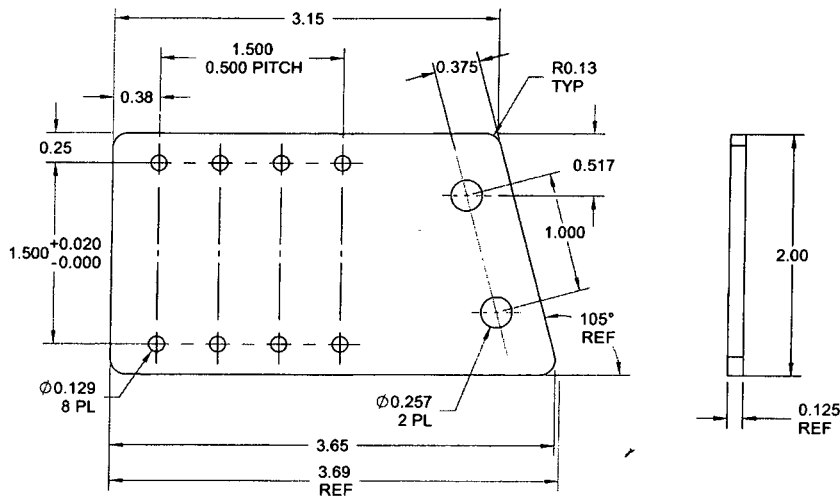


D3912-3 EYEBOLT BLOCK

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs



D3912-5 EYEBOLT PLATE

RELEASED
2010-07-16

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO. D3912	REV. B
MFG. APPR.	ALS		SHEET 3 OF 3
APPROVED	ALS	TITLE EYEBOLT RECEIVER ASSY	SCALE NTS
DE APPR.	ALS		
DATE	10.06.28		

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